

5/04

DART AEROSPACE LTD	Work Order:	22103
Description: Wearshoe	Part Number:	D2656-35
Drawing: D2656 Rev. C	Qty:	50 52 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	JF	04.12.14	50
2	PG	Issue P/O: <u>1007328</u> Email or ship DXF file to vendor Laser Cut per Dwg D2656 flat pattern D2656-35 Material release note required	DR	04/12/16	50
3	RG	Receive and Inspect for transit damage Ensure the material note is attached	CD	05/01/16	53
4	QC6	Inspect dimensions per template D2656-35T1	Z	05.08.16	52
5	GB	Deburr if necessary	RF	05.08.16	52
6	GB	Form, on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. Identify as D2656-35.	RF	05.08.16	52
7	QC5	Inspect work to Step 6	Z	05.08.16	52
8	FP	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	FC	05.08.22	52
9	QC3	Inspect Powder Coat	ML	05.08.23	52
10	FP	Identify and Stock	FC	05.08.24	52
11	AC	Cost / part: <u>9.48</u>	SAC	05.08.25	52
12	DC	Close W/O <u>9.69</u> Inspect Level 21	JF	05/08/25	52

(PTO)

Rev	Date	Change	Revised By	Approved
A	97.12.04	New Issue		
B	99.03.16	Re-format	DM	
C	00.11.01	Removed P/O for powder coat – in house process	EC	
D	02.10.25	Re-format	KJ RF	JF

RELEASED
02/10/2017 RF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-08-16	4	Task 1 for template 02656-3571		J	05-08-16	1		2 05-08-16

NCR:		WORK ORDER NON-COMFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 05/08/16

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 13, 2004
11:38 am

Work Order No	:	0022103	Department Code:		
Project Name	:	D2656-35	Burden Flags	:	NNNNNNN
Project For	:	WK504	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D2656-35	Invoice Number	:	
Description	:	Wearplate	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	50	Order Entry No	:	
Amount Done	:	0	OE Value	:	0.00
Start Date	:	12-13-04	Est Margin	:	0.000%
Est Finish Date	:	01-28-05	Actual Margin	:	0.000%
Act Finish Date	:				
Drawings Reqd	:	No			
Ok for Approval	:				
Approval Rec'd	:				\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
<hr/>					
Burden	:	0.00	0.00	0.00	
<hr/>					
Total Cost	:	0.00	0.00	0.00	
Margin	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/(Loss)	:	0.00	0.00



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TEST CERTIFICATE

Ref: 3561/12021

CUSTOMER	Wilkinson	P-30430NT001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC072790																	
CUSTOMER QIN	90-21N-141		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																	
MILL QIN	375624		DIMENSIONS	0.033" x 48" x Coil	DATE	29 August 2003																	
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT										MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)											
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	TS.	%ELONG	HARDNESS	r
R9-413484-00	625796	5	TR	20	8	9	12	18	20	1	5	1	1		x1000	x10000	x100	180°		GL=	HRB	()	(feet)
R9-413485-00	625796	5	TR	20	8	9	12	18	20	1	5	1	1								44		2467
R9-414003-00	625794	5	I	20	8	11	12	18	21	3	6	1	1								44		2589
R9-414004-00	625794	5	I	20	8	10	12	18	21	3	6	1	1								49		2644
																					49		2690

20 GA MS

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm (C)=50mm (D)=5.657 So (E)=2° (F)=δ°	PLASTIC STRAIN RATIO (I) (A)=FU (B)=F90 (C)=45 (D)=(F90/FU-2)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+V/16 (B)=C+V/16+(Cr+V+Mo)/5+(Cu+N)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
OC METALLURGIST

